Work Order ID 72615

Wednesday, August 03, 2011 3:46:55 PM

Item ID: D3997-13 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Placard

Start Date: 8/3/2011 **Start Qty:** 10.00 **Cust Item ID:**

Required Date: 8/4/2011 **Req'd Qty:** 10.00 **Customer:**

Reference:

Approvals: **Process Plan:** H **Date:** 11-08-3 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D3997 / Revision Nbr: A									
100 Purchasing Purchasing	**Memo** Issue P/O: 14619 Manufacture as per Dwg D3997 Possible Supplier:Studio Lettrage Material release note required	0.00 0.00							11-08-3 10
110 Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs **Memo**	0.00 0.00							11/8/4 (10)
120 QC Quality Control	QC6- Inspect dimensions to drawing **Memo**	0.00 0.00							S wlos/11 (14)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 72615

Wednesday, August 03, 2011 3:46:55 PM

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: 104	0.00							
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10/8/12 — 14

CK 11/08/12

11-8-12 — 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 03, 2011 3:47:00 PM

Work Order ID: 72615

Parent Item: D3997-13

Parent Item Name: Placard

Start Date: 8/3/2011 **Required Date:** 8/4/2011

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP rev A 10.01.12 new issue Prelim EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-13P Placard		Purchased	No				Each	0.0000		10			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

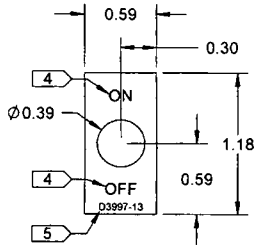
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

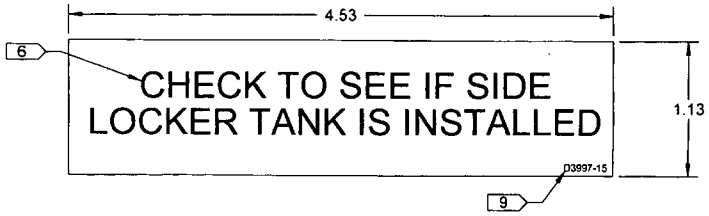
NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3997-13	JCA-M47-P7
D3997-15	JCA-M47-P8
D3997-17	JCA-M47-P9
D3997-19	JCA-M47-P10

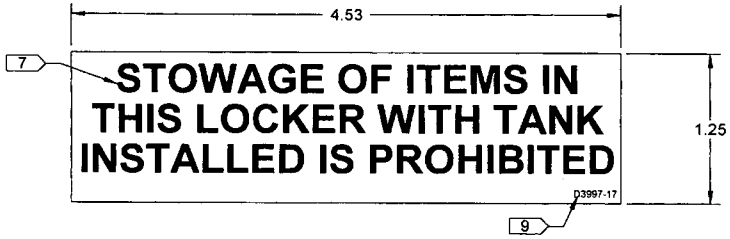
PART NUMBER	INSTALLATION INSTRUCTIONS
D3997-13	AROUND FUEL PUMP ON/OFF SWITCH
D3997-15	ON BAGGAGE LOCKER OUTER SURFACE BELOW RELEASE BUTTON
D3997-17	ON TANK OUTBOARD SURFACE
D3997-19	AT VENT LINE OUTLET ON AIRCRAFT



D3997-13 PLACARD



D3997-15 PLACARD



D3997-17 PLACARD



D3997-19 PLACARD

RELEASED
2010 -01- 11

NOTES:
1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
3) UNITS: INCHES UNLESS OTHERWISE NOTED
4) 10 PT FONT, WHITE TEXT ON BLACK BACKGROUND
5) 6 PT FONT, WHITE TEXT ON BLACK BACKGROUND
6) 22 PT FONT, BLACK TEXT ON WHITE BACKGROUND
7) 24 PT BOLD FONT, BLACK TEXT ON WHITE BACKGROUND
8) 18 PT BOLD FONT, BLACK TEXT ON WHITE BACKGROUND
9) 6 PT FONT, BLACK TEXT ON WHITE BACKGROUND

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3997 REV. A
MFG. APPR.		SHEET 3 OF 6
APPROVED		TITLE PLACARD SCALE NTS
DE APPR.		
DATE 09.10.05		

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Studio de Lettrage

210 Main Street W
Hawkesbury, Ontario K6A 2H6

INVOICE

Invoice No.: 16152
Date: 08/08/2011
Ship Date:
Page: 1
Re: Order No. 11242

Sold to:

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario
K6A 1K7

Ship to:

Dart Aerospace Ltd
Hawkesbury, Ontario

Business No.: 82500 7651 RT0001

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
		10	D3997-3P setup	H	5.00	50.00
		100	D3997-5P set up	H	0.50	50.00
		10	D3997 7P set up	H	5.00	50.00
		10	D3997 -9P set up	H	5.00	50.00
		10	D3997-11P setup	H	5.00	50.00
		10	D3997-13P set up	H	5.00	50.00
		10	D3997-15P set up	H	5.00	50.00
		10	D3997-17P set up	H	5.00	50.00
		10	D3997-21P set up	H	5.00	50.00
		10	D3997-23P set up	H	5.00	50.00
		10	D3997-27P set up	H	5.00	50.00
		10	D3997-29P set up	H	5.00	50.00
		10	D3997-31P set up	H	5.00	50.00
		10	D3997-33P setup	H	5.00	50.00
		10	D3997-35P setup	H	5.00	50.00
		10	D3997-37P setup	H	5.00	50.00
		10	D3007-39P setup	H	5.00	50.00
		10	D3997-41P setup	H	5.00	50.00
		10	D3997-43P setup	H	5.00	50.00
		1	printing	H	450.00	450.00
			H - HST 13%			
			HST			182.00
			PST Exempt: #6122-5207			

Studio de Lettrage HST: #869034678RP001

Shipped By: Tracking Number:

Comment: PO 14612

Sold By:

Total Amount 1,582.00

3M

Scotchcal™
Opaque Imaging Media 8522

Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long–term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

Advantages

- Optimized for use with selected Epson Stylus Pro printers and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
 - For opaque (reflective) graphics
 - Changeable, easy to remove from warranted substrates up to 1 year later
 - Dries quickly after printing so the overlaminate can be applied almost immediately
 - Low slippage paper liner for superior tiling
- Overlaminates:
 - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
 - Available in luster and matte gloss
 - Adhesive allows for heat-assisted or cold-temperature lamination

Applications and Uses

3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M™ MCS™ Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
 - Graphics for vans, personal vehicles, trucks and buses
 - Novelty posters
 - Retail and point-of-purchase displays
 - Information graphics such as maps and directories
 - Entertainment promotions in museums, zoos, parks, theatres, sports venues
 - Education and presentation graphics
 - Legal and courtroom exhibits
- For flat or simple curved surfaces, with or without rivets, used in vertical (± 10°) applications

Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non–warranted substrates, including wallboard
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

Compatible Products and Equipment

Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
 - Epson Archival Inks
- Epson Stylus Pro 10600 printer
 - Epson Archival Inks
- HP DesignJet Printers 2000 and 3000 series
 - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
 - HP83UV Color Ink System

Overlaminates (required)

- 3M™ Luster Overlaminate 8519 (semi-gloss)
- 3M™ Matte Overlaminate 8520

Note: For the full product names of the 3M products listed on this page, please see page 1.

Warranted Substrates

Media 8522 is warranted for use on the following rigid substrates.

Some substrates may "out-gas", resulting in tiny bubbles throughout the surface of the graphic. For maximum performance, be sure the substrate you select is properly cleaned and prepared as recommended by the manufacturer. See Instruction Bulletin 5.1 for additional information.

- Alodine (anodized aluminum)
- Automotive panels (automotive painted steel)
- Fruehauf (painted aluminum)
- FRP (fiberglass reinforced plywood)
- Glass
- Imron® (polyurethane-painted metal panel)
- Acrylic
- Sintra™ board

Test and Approve Non-warranted Substrates Before Use

Media 8522 is not warranted for any substrate other than those listed above. If you want to use it for other substrates, 3M recommends that you test and approve the media for both adhesion and removal characteristics.

Characteristics

Characteristic	Description
Media	7 mil, white, opaque graphic film
Liner	Low-slippage, lay flat paper
Adhesive	Changeable, pressure sensitive
Thickness (media and adhesive)	7.5 to 8 mil (nominal)
Application substrates	See Warranted Substrates, above
Application surfaces	Flat or simple curved surfaces, with or without rivets, used in vertical (± 10°) applications (no corrugations)
Application temperature range	28° to 110°F (-2° to 43°C) (air and surface)
Roll sizes	36" x 45 feet (914 mm x 13.5 m) 54" x 45 feet (1372 mm x 13.5 m)

How to Become a 3M Ink Jet Registered Fabricator

Only 3M Thermal Ink Jet Registered Fabricators are eligible to offer 3M MCS warranted graphics. In order to become certified, a fabricator must complete the requirements as specified in the 3M Ink Jet Graphics Registered Fabricator Reference Manual located on the 3M website at www.scotchprint.com

Effective Performance Life

To obtain the warranty given below, the graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3. Also see the section, Removability.

Warranted Durability

Media 8522 with Overlaminate 8519 or 8520	Epson Printers		HP Printers	
	Outdoor	Indoor	Outdoor	Indoor
Applied to Warranted Substrates	2 years	5 years	3 years	5 years

Removability

Imaging media 8522 is removable from warranted substrates for 1 year without the aid of chemical strippers or accessories. Refer to Instruction Bulletin 4.23 for additional information.

Fabrication

Graphics must be made according to 3M's recommendations which are detailed in the Warranty and Limited Remedies on page 3.

See Instruction Bulletin 4.23 for detailed fabrication, printing and mounting information.

Graphic Construction Options

Opaque (Reflective) Graphics

Opaque graphics made with imaging media 8522 require an overlaminate and an opaque substrate.

